

Work Order ID 152138

Thursday, October 27, 2016 3:48:16 PM

152138

Page 1

Item ID: D350-588-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Door Assembly

Start Date: 10/25/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/26/2016 Req'd Qty: 1.00

1

Customer: CAIRM02

Reference: RMA RA112375

Approvals: Process Plan: UMF

Date: 16-10-27

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2445/D350-588

Rev D/D

DSI9690

A

SCRAP

100

100

QC

Quality Control

Memo

INSPECT RA112375

D350-588-041 X 1 B139281

DOOR NEEDS TO BE SENT OUT FOR REPAIR

REMOVE AND ID :

• D2143 X 1 B121806

• D2144 X 1 B114332

• D2585 X 2 B139075

• D2586 X 2 B139228

• D2621 X 2 B127749

• D2857-1 X 1 B133964

• D2857-2 X 1 B133903

SCRAP D2463-0870 AND ALL HARDWARE

DAS
07
9-89

17/01/17

DAS
07
9-89

17/01/17

105*
SMALL FAB

x/

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Customer: CAIRM02

Reference: RMA RA112375

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00

110

Purchasing

Memo

0.00

Purchasing

SEND OUT TO FDC FOR REWORK:

Issue P/O: 35626

Description: D2445 Baggage Door

Supplier: FDC composite

Ship to supplier (1) D0588-041 label

Certification of Conformity and process sheet is required.

/

MAR 17 2017

DAS

13

CCT

120

Receive & Inspect for Damage & Mat'l Certs

0.00

120

Packaging

Memo

0.00

Packaging

Ensure Certificate of Conformity & Process Sheet are attached

N/A

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130

QC6- Inspect dimensions to drawing

0.00

130

QC

Memo

0.00

Quality Control

Inspect as per Dwg D2445.

Audit process sheet.

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Revision ID:

Stop ***NS2***

Item Name: Aft Door Assembly

Start Date: 10/25/2016 Start Qty: 1.00

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Cust Item ID:

Required Date: 10/26/2016 Req'd Qty: 1.00

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Customer: CAIRM02

Reference: RMA RA112375

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
140									
Small Fab	Memo	0.00							
Small Fab	Assemble all of the above parts as per Dwg D350-588								
	AFTER REWORK IS COMPLETE FROM FDC, TRIAL FIT DOOR AND ASSEMBLE WITH ORIGINAL KIT AND NEW HARDWARE								
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Pick Kit	0.00							
160									
Packaging	Memo	0.00							
Packaging	ENSURE ORIGINAL KIT IS WITH DOOR								

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Item ID: D350-588-041

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Door Assembly

Start Date: 10/25/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/26/2016 Req'd Qty: 1.00

1

Customer: CAIRM02

Reference: RMA RA112375

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

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Picklist Print

Page 1

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Work Order ID: 152138

152138

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 10/25/2016

Required Date: 10/26/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP P 04.02.04ReformatKJ/DS IPP Rev:Q as
per DSI9414 DD verified by:EC IPP Rev:R add pick kit DD
10.03.29 verified by:EC IPP REV:S 14.04.28 AS PER
DSI9690 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D350-588-041

Manufactured No

Each 0.0000

1

D350-588-041******UMF 139281 16-10-27

Aft Door Assembly

Picklist Print

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Work Order ID: 152138

152138

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 10/25/2016

Required Date: 10/26/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP P 04.02.04ReformatKJ/DS IPP Rev:Q as
per DSI9414 DD verified by:EC IPP RevR add pick kit DD
10.03.29 verified by:EC IPP REV:S 14.04.28 AS PER DSI9690 DD
VERF:JLM IPP RevT 17.06.01 DSI9760-011 DP Verify DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2143 *D2143* Hinge Bracket		Manufactured	No				Each	34.0000		-1		JUL 27 2017	
**													

Location	Loc Qty	Loc Code
ST002	34	
121806	3	
141033	1	
150285	8	
152427	10	
156245	12	

D2144 *D2144* Hinge Doubler	Manufactured	No
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Location	Loc Qty	Loc Code
ST002	21	
114332	3	
150971	18	
ST012a	14	
156274	14	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

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Work Order ID: 152138

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 10/25/2016

Required Date: 10/26/2016

Start Qty: 1.00

Required Qty: 1.00

D2585

Manufactured No

Each

55.0000

D2585

Latch Clamp

**

-2

JUL 27 2017

Location

Loc Qty

Loc Code

ST008

55

139075

6

152476

9

156309

4

161798

18

162498

18

D2586

Manufactured No

Each

53.0000

D2586

Door Latch

**

-2

JUL 27 2017

Location

Loc Qty

Loc Code

FG

12

139228

6

152211

4

154875

2

ST448a

31

139228

6

161467

25

ST481

10

154875

10

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 152138

152138

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 10/25/2016

Required Date: 10/26/2016

Start Qty: 1.00

Required Qty: 1.00

D2621

Manufactured No

Each

34.0000

D2621

Latch Plate

**

-2
JUL 27 2017

Location

Loc Qty

Loc Code

FG

2

88616

2

ST009

32

127749

6

141106

1

142793

10

150495

15

D2857-1

Manufactured No

Each

22.0000

D2857-1

Hinge Bracket

**

-1
JUL 27 2017

Location

Loc Qty

Loc Code

FG

5

144748

1

150331

3

91914

1

ST012

17

133964

3

152448

14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 10/25/2016

Required Date: 10/26/2016

Start Qty: 1.00

Required Qty: 1.00

D2857-2

Manufactured No

Each

32.0000

D2857-2

Hinge Bracket

**

-1

JUL 27 2017

Location

Loc Qty

Loc Code

FG

9

140972

2

152184

7

ST012

11

133903

3

152184

8

ST012a

12

161675

12

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					